

NAVY SHIPS PARTS CONTROL CENTER				CODE IDENT		SPI NO.	
SPECIAL PACKAGING INSTRUCTION(SPI)				03950		10084	
NOMENCLATURE OXYGEN MEASURING CELL				NATIONAL STOCK NO. 1H 6630-01-226-0268		DATE 18 MAY 1995	
REV C		MAX. UNIT PACKAGE WT.		MAX. UNIT PACKAGE CUBE		MAX. UNIT PACKAGE DIMS.	
DWN BY <i>MLK</i>		APP BY <i>[Signature]</i>		SHEET <u>1</u> OF <u>2</u>			
1		1 LB		.017 CU FT		3" X 2½" X 2½"	

PACKAGING REQUIREMENTS DATA PER MIL-STD-2073:

H	M	QUP	ICQ	PRES METH	C D	PRES MTL	WRAP MTL	CUSH DUNN	C T	UNIT CONT	L P	INT CTR	U C L	SPEC MKG	PACK- ING	UNIT PACK WGT.	UNIT PACK CUBE	O P I
N		001	AAA	ZZ	X	00	XX	XX	X	XX	A	E2	O	ZZ	EQQ	1.00	.017	A

1. Cleaning. Items shall be manufactured in a "clean room" environment per MIL-STD-209H. All component parts shall be cleaned prior to the assembly of the cell. The cleaning process will include ultrasonic cleaning with either trichloroethylene, acetone, or methanol solvents. All tools used in the assembly of the cells will be cleaned frequently by the same method as the cell. After assembly, each cell shall be tested and individually packaged in the "clean" environment. Each cell will be dosed with pure oxygen at 5PSIG for one (1) minute and then hermetically sealed in inert, oil free, water free gas. The inert gas used for packaging shall be water-pumped, oil-free nitrogen.

2. Packaging. Cleanliness of protective packaging materials shall be equal to the cleanliness requirements of the item being packaged. After the cell is assembled and cleaned as described above, it shall be packaged as follows:

(a) Barrier Bags - Each cell shall be double bagged. Initial barrier bag shall contain inert, dry, oil free, water free, nitrogen gas. Both bags shall be fabricated from 6.0 mil, Type I, watervapor-proof, waterproof, greaseproof, Class I, MIL-B-22191D. The bags shall be heat sealed and must pass all heat-seal tests of MIL-P-116. The outer bag shall be large enough to permit two subsequent resealings if the inner bag is removed and reinserted. Pink, blue, green, or other colors of bagging material are unacceptable. Bags must be sealed with the printing on the outside.

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(b) Labeling - Each outer barrier bag shall have a warning label, fabricated from green paper similar to FED-STD-595B, Color 14187. Lettering shall be easily read and the color black is preferred. White lettering is also acceptable.

"WARNING - THIS PART HAS BEEN CERTIFIED OXYGEN CLEANED  
FOR OXYGEN SERVICE  
DO NOT OPEN UNTIL READY FOR USE"

(c) Unit Container - Use of a "soft" unit container (i.e., a barrier bag) requires a "hard" intermediate container (i.e., fiberboard box). Sufficient cushioning to protect the bagged item shall be used inside the box. The use of loose-fill polystyrene (peanuts or other shapes) excelsior, newspaper or shredded paper (all types, including wax paper) as cushioning or filler is prohibited.

3. Closure - The closure for ASTM-D-5118D/5118M, fiberboard containers, shall be in accordance with ASTM-D-1974.

4. Marking - Each unit container shall also contain the warning label of paragraph 2(c) and MIL-STD-129 markings. Intermediate and shipping containers shall be marked per MIL-STD-129 and shall be stamped or marked "SPECIAL CLEAN 02-N2" (minimum of 1/2" in height).

5. Packing for shipment shall be accomplished in accordance with the data requirements of MIL-STD-2073.